

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-016366**Date Inspected:** 13-Aug-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Qiu Wen**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower & OBG Components**Summary of Items Observed:**

On this date Caltrans Office of Structural Materials Quality Assurance Inspector, Sandeep Kumar (QA) was present during the times noted above for observations relative to the work being performed.

BAY#10

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Weld joint # 10 located on South tower Lift-5 Grillage Assembly SSD1 – TL5 – 1B/F. Welder is identified as 050289. ZPMC Quality Control (QC) Inspector is identified as Li Peng Fei. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3213 – TC – U4c.

Weld joint # 80 located on South tower Lift-5 Grillage Assembly NSD1 – TL5 – 3B/F. Welder is identified as 066443. ZPMC Quality Control (QC) Inspector is identified as Li Peng Fei. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3213 – TC – U5b.

(See attached photo)

ORTHOTROPIC BOX GIRDER (OBG) AT BAY#10

This QA Inspector observed the following work in progress

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Fluxcored Arc Welding (FCAW):

Weld joint # 074 located on Bike Path panel Assembly BK004A6– 032. Welder is identified as 053869. ZPMC Quality Control (QC) Inspector is identified as Yang Ming Ming. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2131.

Weld joint # 085 located on Bike Path panel Assembly BK004A6– 031. Welder is identified as 040533. ZPMC Quality Control (QC) Inspector is identified as Yang Ming Ming. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2131.

BAY#11

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Weld joint # 23 located on East tower Lift-5 Grillage Assembly ESD1 – TL5 – 2B/F. Welder is identified as 040611. ZPMC Quality Control (QC) Inspector is identified as Ma Qian Li. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3213 – TC –U4c.

Weld joint # 03 located on West tower Lift-5 Grillage Assembly WSD1 – TL5 – 4F/F. Welder is identified as 066163. ZPMC Quality Control (QC) Inspector is identified as Ma Qian Li. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3213 – TC –P5.

Heat Straightening:

Heat Straightening being performed on Tower Lift-5 splice plate stiffener identified as ESD1-SPSA5-17 by oxy-acetylene flame method to remove the distortion that occurred after welding. ZPMC Quality Control (QC) Inspector is identified as Liu Dao Feng present at the location. This activity appeared to comply with the Heat Straightening Report # HSR1 (T) – 11496. (See attached photo)

ORTHOTROPIC BOX GIRDER (OBG) AT BAY#11

This QA Inspector observed the following work in progress

Fluxcored Arc Welding (FCAW):

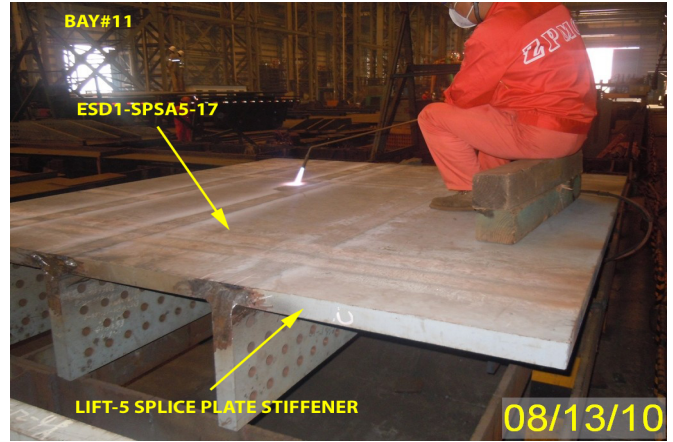
Weld joint # 39 located on Bike Path panel Assembly BK004C7– 022. Welder is identified as 053316. ZPMC Quality Control (QC) Inspector is identified as Wang Chuang Xin. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2133.

Weld joint # 187 located on Bike Path panel Assembly BK004C7– 022. Welder is identified as 047506. ZPMC Quality Control (QC) Inspector is identified as Wang Chuang Xin. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2133.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

No Relevant Conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Michael Ng - 15921845703, who represents the Office of Structural Materials for your project.

Inspected By: Kumar,Sandeep

Quality Assurance Inspector

Reviewed By: Clifford,William

QA Reviewer